

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016679**Date Inspected:** 30-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Heavy Dock Jetty

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040655 perform SMAW welding on; Cross Bracing Gusset and Skin A of East shaft, Lift 3, in 89 mtr. elevation and the weld joint is identified as WD1-GUSA3-3-89 mtr.-E-3B. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U5B-FCM.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 202323 perform SMAW welding on; Cross Bracing Gusset and Skin A of West shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as WD1-GUSA3-3-109 mtr.-W-3A. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2212-TC-U5B-FCM. (Photo attached)

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052910 perform SMAW welding on; Cross Bracing Gusset to Filler plate in Skin A of North shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as NSD1-FASA3-1 B/E-30, 34. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance

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with WPS-B-T-4212-TC-U4C-4. (Photo attached)

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as South shaft, Lift 3 –Cross bracing Gusset to Skin A welding at Tower trial assembly, Heavy Dock Jetty (Notification no. 06534) and Weld repairs of South Shaft, Lift 2 in Heavy Dock (Notification no. 06528). The weld designation reviewed is as follows:

WD1-GUSA3-3-109-S –Jt. no. 3 A/B –South shaft, Lift 3

SSD1-TL5C/L –Jt. no. 214 –Skin E Porosity

SSD1-TL5 D/L –Jt. no. 53

SSD1-TL5E/L –Jt. no. 46 –62mtr.- Porosity

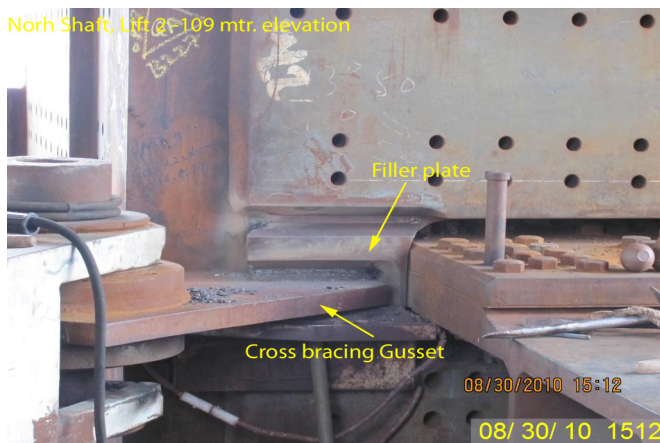
SSD1-TL5E/L –Jt. no. 67 –65 mtr. – Porosity

SSD1-TL5E/L –Jt. no. 77

Gouge mark – 71mtr. elevation

Corner porosity –Skin C -74mtr. elevation

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

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Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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